



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2672
Job Sheet 169306



Part No: D2672

Job Qty: 4 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/7/17

Job Tracking No:

Due Date: 12/22/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B1

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		12/21/17	0.00	0.00	Start Up Waterjet		OK 17/12/07
120	Waterjet	4 pcs		12/21/17	0.00	0.85	Waterjet1		OK 17/12/07
130	CNC Vertical Machining	4 pcs		12/22/17	0.72	4.61	HAAS1-2		SC 17/12/17
140	QC	4 pcs		12/22/17	0.00	0.00	QC2 Machining-1		SC 17/12/17
150	QC	4 pcs		12/22/17	0.00	0.00	QC8 Machining-1		SC 17/12/17
180	Packaging	4 pcs		12/22/17	0.00	0.00	Packaging3		SC 17/12/17
190	QC21-SA	4 Ea		12/22/17	0.00	0.00	QC21		SC 17/12/17

Part Op 120 - Cut Blank as per File D2672_BLANK

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA791 and Dwg D2672. Identify as D2672

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10	14	1,063	0	0

Part Specifications

Specifications could not be found.

Plex 12/7/17 8:40 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water lot ☐ Engineering Quality Other ☐ Therm ☐																																																																										
Date : _____ Step #: _____		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																																										
Description Work Order Deviation																																																																												
Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:50%; vertical-align: top;"> <table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td></tr> </table> </td> <td style="width:50%; vertical-align: top;"> <table style="width:100%; border-collapse: collapse;"> <tr><td>No Re-verification</td><td>☐</td></tr> <tr><td>Operator</td><td>☐</td></tr> <tr><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Supplier</td><td>☐</td></tr> <tr><td>Training</td><td>☐</td></tr> <tr><td>Use for Testing</td><td>☐</td></tr> <tr><td>Poor Information</td><td>☐</td></tr> <tr><td>Rushing</td><td>☐</td></tr> <tr><td>Product Improvement</td><td>☐</td></tr> <tr><td>Process Improvement</td><td>☐</td></tr> <tr><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Past Due</td><td>☐</td></tr> </table> </td> </tr> </table>		<table style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td></tr> </table>	Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	<table style="width:100%; border-collapse: collapse;"> <tr><td>No Re-verification</td><td>☐</td></tr> <tr><td>Operator</td><td>☐</td></tr> <tr><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Supplier</td><td>☐</td></tr> <tr><td>Training</td><td>☐</td></tr> <tr><td>Use for Testing</td><td>☐</td></tr> <tr><td>Poor Information</td><td>☐</td></tr> <tr><td>Rushing</td><td>☐</td></tr> <tr><td>Product Improvement</td><td>☐</td></tr> <tr><td>Process Improvement</td><td>☐</td></tr> <tr><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Past Due</td><td>☐</td></tr> </table>	No Re-verification	☐	Operator	☐	Offset/Setup	☐	Supplier	☐	Training	☐	Use for Testing	☐	Poor Information	☐	Rushing	☐	Product Improvement	☐	Process Improvement	☐	Manufacturing Process	☐	Past Due	☐	<table style="width:100%; border-collapse: collapse;"> <tr><td>Pressure/Forced</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td></tr> <tr><td>OTHER :</td><td>☐</td></tr> </table>			Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	☐	OTHER :	☐
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DART AEROSPACE
S018934

 Bearpaw

D2672

 Start up Operation

PART NO:
 Revision:
 Operation:
 Change No:

Mfg Date: 12/07/17
 Job No: 169306

QSI042) Approval

 Completed By

 and / Supervisor
 Approval Verification

 QA Coordinator
 Approval

 oned Wrong
 de Dimensions
 'Under tolerance
 ncorrect
 ost/Missing
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 ad
 ig Sequence

DART AEROSPACE LTD		Work Order: 169306
Description: Bearpaw		Part Number: D2672
Inspection Dwg: D2672	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 23.750	+/-0.030	23.750	✓		TAPE	
B 12.750	+/-0.030	12.750	✓		TAPE	
C 4.250	+/-0.010	4.252	✓		Ver	EDL
D 2.000	+/-0.030	2.015	✓		Ver	ED6
E 9.000	+/-0.010	9.003	✓		Ver	CNC 02
F 0.375	+/-0.030	0.383	✓		Ver	ED6
G 9.000	+/-0.010	9.003	✓		Ver	CNC 02
H Ø0.260	+0.005/-0.000	0.260	✓		G.P	
I Ø0.93	+/-0.030	0.93	✓		Ver	ED-6
J 0.300	+0.030/-0.000	0.315	✓		Ver	ED-6
K 0.625	+/-0.030	0.625	✓		Ver	ED-6
L 0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓		Ver	ED-6
M 0.250	+/-0.010	0.249	✓		Mic	6501135)
N 5.500	+/-0.030	5.506	✓		Ver	ED-6
O R0.250	+/-0.030	R0.250	✓		R.G.	
P 0.200	+/-0.030	0.180	✓		Depth G.	KI-04
Q 0.25 x 45°	+/-0.030	0.25 x 45°	✓		TAPE	
R 0.950	+0.030/-0.010	0.950	✓		Ver	ED-6
S 0.375	+/-0.010	0.379				

Measured by: SL	Audited by: ml	Prototype Approval:	N/A
Date: 17/12/20	Date: 17/12/20	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	